

Work Order ID 52280 -2
 Tuesday, September 22, 2009 1:26:42 PM

Split -2
8/10/7



Item ID: D2530 *BK* Accept Setup Start
 Revision ID: B Stop
 Item Name: Handle Weldment
 Start Date: 9/23/2009 Start Qty: ~~10.00~~ *5*
 Required Date: 10/2/2009 Req'd Qty: ~~10.00~~ *5*
 Reference: Cust Item ID:
 Customer:
 Approvals: Process Plan: *PP MW* Date: *09-9-22* Tooling: Date:
 QC: Date: SPC (Y/N): Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2530	Rev B								

100

 Small Fab
 Small Fab

Small Fab 0.00
 Memo 0.00
 1-Cut to length as per Dwg D2536□2-Debur *M. L. 09/10/01* *(10X)*

110

 QC
 Quality Control

QC5- Inspect part completeness to step on W/O 0.00
 Memo 0.00 *2) 50210102* *(40)* *φ*

120

 Small Fab
 Small Fab

Small Fab 0.00
 Memo 0.00
 1-Weld as per Dwg D2530 and QSI 004 using Welding Jig DT8301□2-Debur

SM 09/10/05 *(5X)*
SM 09/10/08 *(5X)*

(P/E) →

I/O: 52280

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		wp was split for 5 Due to missing parts	S	2/10/7	5		S 02/10/07

Part No: D2530 PAR #: Fault Category: NCR: Yes No DQA: Date: Resolution: Disposition: QA: N/C Closed: Date:

WORK ORDER NON-CONFORMANCE (NCR)

NCR:								
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D2530

Accept



Setup Start



Revision ID: B

Item Name: Handle Weldment

Stop



Start Date: 9/23/2009 Start Qty: 10.00



Cust Item ID:

Required Date: 10/2/2009 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

130



QC

Quality Control

Operation
Description

QC9- Inspect visual per QSI004- Fusion Welds

Set Up/
Run Hours

0.00

Draw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Memo

0.00

AD 09.10.07 (5)
PD 09.10.08 (5)

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

2) 8 or 10/09

(15) 4

150



Powdercoat

Powder Coating

Black Sandtex (Ref: 4.3.5.7) per QSI005 4.3

0.00

Memo

0.00

BH 09-10-9

(5)

START TIME:

9:00

OVEN TEMPERATURE:

3:20 FINISH TIME:

9:30

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Item ID: D2530

Revision ID: B

Item Name: Handle Weldment

Start Date: 9/23/2009 Start Qty: 10.00

Required Date: 10/2/2009 Req'd Qty: 10.00

Reference:

Accept



Setup Start

Stop



Cust Item ID:

Customer:



Run Start

Stop



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC3- Inspect Part Finish

0.00

*ll**09/10/09**(15) 0*

QC

Memo

0.00

Quality Control

170

Identify as per dwg & Stock Location: *506*

0.00



Packaging

Memo

0.00

Packaging

Pc 9/10/9 (5)

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

*09/10/13**ME 09-10-13*

Work Order ID: 52280
 Parent Item: D2530RevB
 Parent Item Name: Handle Weldment



Start Date: 9/23/2009

Required Date: 10/2/2009

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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D2534RevD
 Lock Plate

Manufactured No

100

Each

10.0000

20.0000



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

10

47176

10

120

f

286.3500

30.6789



10x

10x

10/09/10/02
 10/09/10/08

M304TR0.750W.049
 304 RD Tube .750 x .049W

Purchased

No

52569

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

286.35

107518

2.77

108498

0

109314

8.5

110113

0.73

110271

0.03

111096

9

111457

11.43

112652

253.89

mt 09/10/01
 M112800

DART

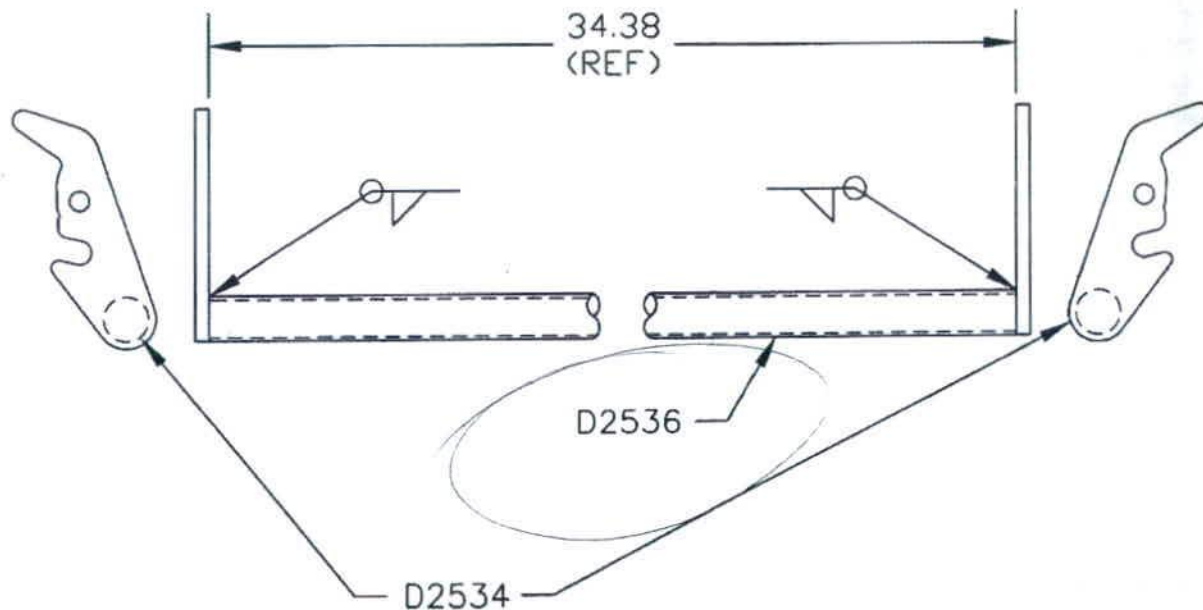
DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
B WILLIAMS	PH	DRAWING NO. D2530	REV. B SHEET 1 OF 1
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	TITLE HANDLE WELDMENT	
DATE 04.12.14		SCALE	
A	96.06.18	NEW ISSUE	
B	04.12.14	UPDATE NOTES AND DIMENSIONS	

RELEASED

04.12.16 *[Signature]*PART LIST -- D2530

QTY	PART NUMBER	DESCRIPTION
X	D2530	HANDLE WELDMENT
1	D2536	HANDLE
2	D2534	LOCK PLATE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 52280

D2530 HANDLE WELDMENT

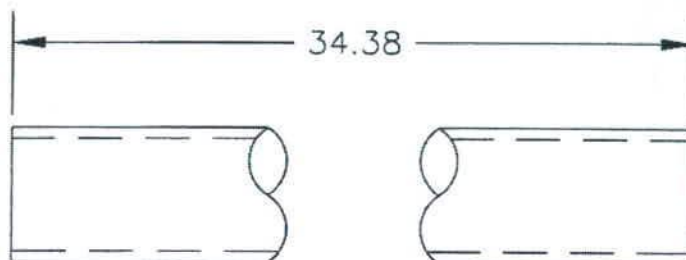
- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT BLACK (4.3.5.7) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
B WILLIAMS	PH	DRAWING NO.	REV. B
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	D2536	SHEET 1 OF 1
DATE	TITLE		SCALE
04.12.14	HANDLE		NTS
A	96.05.15	NEW ISSUE	
B	04.12.14	UPDATE NOTES	

RELEASED04.12.16 *[Signature]*

REFERENCE ONLY

**D2536 HANDLE**

- 1) MATERIAL: AISI 304/316 SS $\phi 0.75$ X 0.049 WALL (REF. DART SPEC. M304TR0.750W.049)
- 2) FINISH: NONE
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

